

Work Order ID 60856

Monday, July 26, 2010 11:28:31 AM

Page 1

Item ID: D2198-1

Accept

Revision ID:

Item Name: Bracket

Start Date: 7/26/2010 Start Qty: 6.00

Required Date: 8/3/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-7-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2198

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2198

Dwg Rev: E

Prog Rev: C

2-Deburr if necessary

10-7-27

8

304 . 063

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-7-27

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8106863

18

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 60856

Monday, July 26, 2010 11:28:31 AM

Page 2

Item ID: D2198-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 7/26/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 6.00

Customer:




Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130  Brake NC Brake NC | NC BRAKE Memo Bend as per dwg D2198 | 0.00 0.00 | | 80 | 10/08/03 | (8) | | | |
| 140  QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | S | 10/08/04 | (X2) | | | |
| 150  Powdercoat Powder Coating | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 11/15/29 Memo POWDER COAT: Start Time: 7:15am Oven Temperature: 400°F Finish Time: 7:45am | 0.00 0.00 | | 2) M | 10/08/10 | X8 | 0 | | |

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Work Order ID 60856

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Page 3

Item ID: D2198-1

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Item Name: Bracket

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Required Date: 8/3/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/08/10 08 10 (8)

170

Identify as per dwg & Stock Location: 8

0.00



Packaging

Memo

0.00

Packaging

10/8/10 SP (8x)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/10

ME
10-8-10

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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 11:28:35 AM

Page 1

Work Order ID: 60856



Parent Item: D2198-1



Parent Item Name: Bracket

Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-24 new issue cc verified by:dd
10.05.03 add powdercoat DD verified :EC

IPP rev:B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S16GA

Purchased

No

100

sf

37.8267

0.125

0.789474

1.



1310-7-27

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

37.82669474

111323

0

114799

37.8266947

114799

②

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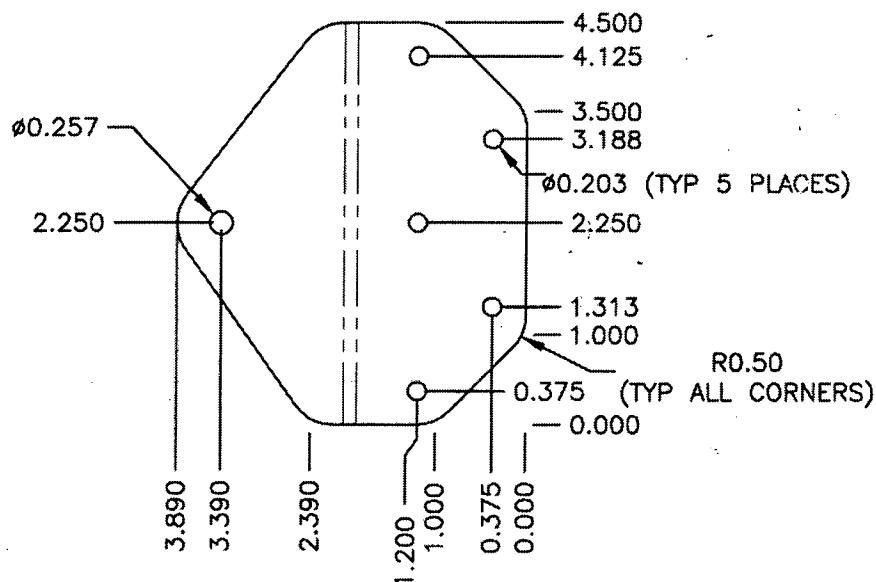
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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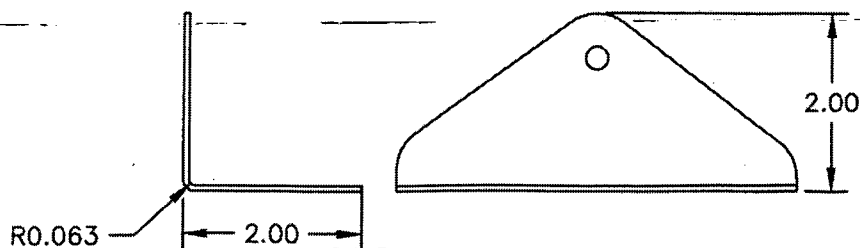
DART

| | | | |
|------------------|------------------|---|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2198 | REV. C SHEET 1 OF 1 |
| DATE 03.05.28 | TITLE BRACKET | | SCALE 1:2 |
| B | 93.10.05 | REDESIGN | |
| C | 03.05.28 | REDRAW | |

RELEASED
03.07.09

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60854

D2198-1
FLAT PATTERN



D2198-1 BRACKET
BEND DETAIL

D2198-1

- 1) MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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